

# Work Order ID 108297

October-15-13 10:04:34 AM

**\*108297\***

Page 1

Item ID: D2571

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, Fwd, Out

Start Date: 10/15/13

Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 10/29/13

Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-10-15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2571

F

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 108297

Double check by: ml

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect

ml 13/10/17

DAS  
40  
9-89

13/10/16

8

8

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

ml 13/10/17

8

8

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## Hand Finishing



Work Order ID 108297

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October-15-13 10:04:34 AM

Item ID: D2571 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Saddle, Fwd, Out  
Start Date: 10/15/13 Start Qty: 8.00 \*8\* Cust Item ID:  
Required Date: 10/29/13 Req'd Qty: 8.00 \*8\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 126 125</i> Memo START TIME: <i>3:10</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>3:46</i>	0.00 0.00				<i>8</i>	<i>φ</i>	<i>13-10-21</i>	DAS 34 9-89
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>8</i>			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST441</i> Memo	0.00 0.00				<i>8x</i>		<i>13-10-22</i>	DAS 28 9-89



Work Order ID 108297

\*108297\*

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Item ID: D2571 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Saddle, Fwd, Out  
Start Date: 10/15/13 Start Qty: 8.00 \*8\* Cust Item ID:  
Required Date: 10/29/13 Req'd Qty: 8.00 \*8\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

*Handwritten:* Rm 13/10/29

*Handwritten:* RB-10-23



# Picklist Print

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Page:1

Work Order ID: 108297

**\*108297\***

Parent Item: D2571

**\*D2571\***

Parent Item Name: Saddle, Fwd, Out

Start Date: 10/15/13

Required Date: 10/29/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007		Manufactured	No			100	Each	41.0000	1	8			
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**\*D6101-007\***

Saddle Billet

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DAS  
40  
9-89

13/10/15

Location

Loc Qty

Loc Code

MAT041

20

92730

20

MAT042

1

103030

1

MAT044

20

106260

20

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
8



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	108297
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.499	.500	.500	.500		
G	0.257	0.262		.258	.259	.259	.259		
H	0.375	0.380		.376	.377	.377	.377		
I	0.490	0.510		.498	.499	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.563	.566	.567	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.251	.252	.252		
S	0.115	0.135		.125	.128	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.245	.241	.240	.240		
W	0.115	0.135		.121	.122	.122	.122		
X	0.308	0.313		.310	.310	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.246	.246	.247		
AE	1.375	1.395		1.386	1.387	1.388	1.387		
AF	0.115	0.135		.130	.132	.131	.135		
AG	0.240	0.280		.250	.258	.258	.258		
AH	0.240	0.260		.253	.249	.249	.249		
AI	2.000	2.020		2.001	2.001	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>40</i>	Audited by: <i>DA</i>
Date: 13/10/16	Date: 13/10/17

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	108297
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.497	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.565	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.128	.130	.130	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.241	.240	.240		
W	0.115	0.135		.122	.123	.122	.122		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.246	.246	.246		
AE	1.375	1.395		1.387	1.386	1.387	1.388		
AF	0.115	0.135		.131	.132	.131	.131		
AG	0.240	0.280		.253	.255	.257	.255		
AH	0.240	0.260		.250	.249	.248	.250		
AI	2.000	2.020		2.001	2.001	2.003	2.0024		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>amk</i>	Audited by: <i>D.A.</i>
Date: 13/10/17	Date: 13/10/19

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	<i>KA</i>

